

Claims

- 5        1.        A hollow plastic article having a desired in-use orientation, the article comprising a hollow body with a lower portion and an upper portion, the hollow article having an outer wall of substantially uniform thickness and the article having an integrally moulded ballast.
- 10       2.        An article as claimed in claim 1 wherein the ballast has substantially the same wall thickness as that of the outer wall of the article.
3.        An article as claimed in claim 1 wherein the ballast comprises a rib extending from the wall of the article.
- 15       4.        An article as claimed in claim 3 wherein the rib extends inwardly from the lower portion of the hollow article.
5.        An article as claimed in claim 3 wherein the rib extends generally radially.
- 20       6.        An article as claimed in claim 1 wherein the ballast comprises a plurality of ribs.
7.        An article as claimed in claim 6 wherein the ribs are spaced-apart peripherally inside the hollow article.
- 25       8.        An article as claimed in claim 6 wherein at least some of the ribs are of differing length.

9. An article as claimed in claim 8 wherein longest rib is provided at the lowest section of the article and the radial extent of the ribs decrease upwardly therefrom.
- 5 10. An article as claimed in claim 1 wherein the hollow body is of generally spherical shape.
- 10 11. An article as claimed in claim 10 wherein the article has integrally moulded ballast ribs which extend generally radially inwardly of the outer wall of the hollow body.
- 15 12. An article as claimed in claim 10 wherein the article comprises a pair of hemispheres which are moulded separately and subsequently bonded together.
- 20 13. An article as claimed in claim 12 wherein each hemisphere has a lower portion and an upper portion and each hemisphere has an integrally moulded ballast in a lower portion thereof.
- 25 14. A process for manufacturing a hollow plastic article having a desired in use orientation, the article comprising a hollow body having a lower portion and an upper portion, comprising the steps of:
- providing a mould which is configured to provide a hollow article having an outer wall of substantially uniform thickness and having integrally moulded ballast features, and
- injection moulding the article.
- 30 15. A process as claimed in claim 14 wherein the mould is configured such that the ballast features are of uniform thickness

16. A process as claimed in claim 15 wherein the mould is configured such that the thickness of the ballast features is the same as the thickness of the outer wall of the article.

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17. A process as claimed in claim 14 comprising the step of separately moulding two articles of substantially hemispherical form, each having an upper portion and a lower portion and integrally moulded ballast features, and subsequently bonding them together to form a hollow article of substantially spherical form.

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